

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW INSTALLATION KIT (13"x24" BENT)
Job Number	: 28731		
Estimate Number	: 12282		
P.O. Number	: N/A	Part Number	: D206559025
This Issue	: 9/26/2006 S.O. No. : N/A	Drawing Number	: D2672 REV B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: N/A	Material	: N/A
Written By	: _____	Due Date	: 10/10/2006
Checked & Approved By	: <u> </u>	Qty:	4
Comment	: Est D 03.05.30 Reformat; Incorporated D2672B IPP KJ/RF	\$ Um:	Each

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 DC DOCUMENT CONTROL



Photocopy bluefile and create labels per PPP D206-559-025 CHG005

K3 06.10.02

2.0	MUHMWB10	UHMW 1" Black
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Batch: 102164

J.F. 06/10/04

4

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Form as per Dwg D2672

J.F. 06/10/04

4

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/10/04

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/26/2006 2:43:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION KIT (13"X24" BENT)

Job Number: 28731

Part Number: D206559025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 06.10.04

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

(Note: D2672B is on the BOM as material from step 3)

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total: 12.5000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion B2842

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block B28524

2 D2432F(ref only) Bearpaw B28731

PP 3 SURT1

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp B28732

✓ 9

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 D2529 Washer B27876

48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/26/2006 2:43:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION KIT (13"X24" BENT)

Job Number: 28731

Part Number: D206559025

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN415A

Bolt



48



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 AN4-15A Bolt M1020392

12.0

AN417A

Bolt



48



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 AN4-17A Bolt M101129 ✓

13.0

AN960JD416

Washer



96



Comment: Qty.: 24.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 24 AN960JD416 Washer M19185 ✓

14.0

MS21042L4

Nut



48



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 MS21042L4 Nut (or -4) M19099

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-559-025

Identify and Stock

Location: NEUB

PC 6/11/20 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/11/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/26/2006 2:43:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION KIT (13"X24" BENT)

Job Number: 28731

Part Number: D206559025

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

④
8/11/21

Job Completion



u 06.11.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

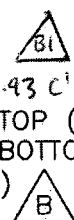
NOTE: Date & initial all entries

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO.	REV. B
DATE 98.05.19		D2672	SHEET 1 OF 2
		TITLE	SCALE
		BEARPAW	1:5
		NEW ISSUE	
		CHANGE C'BORE, R1.58 WAS R1.50	
		φ0.93 WAS φ0.75	

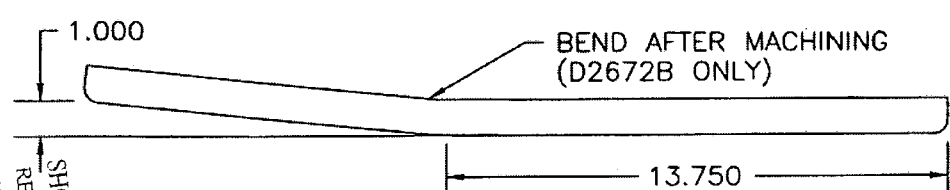
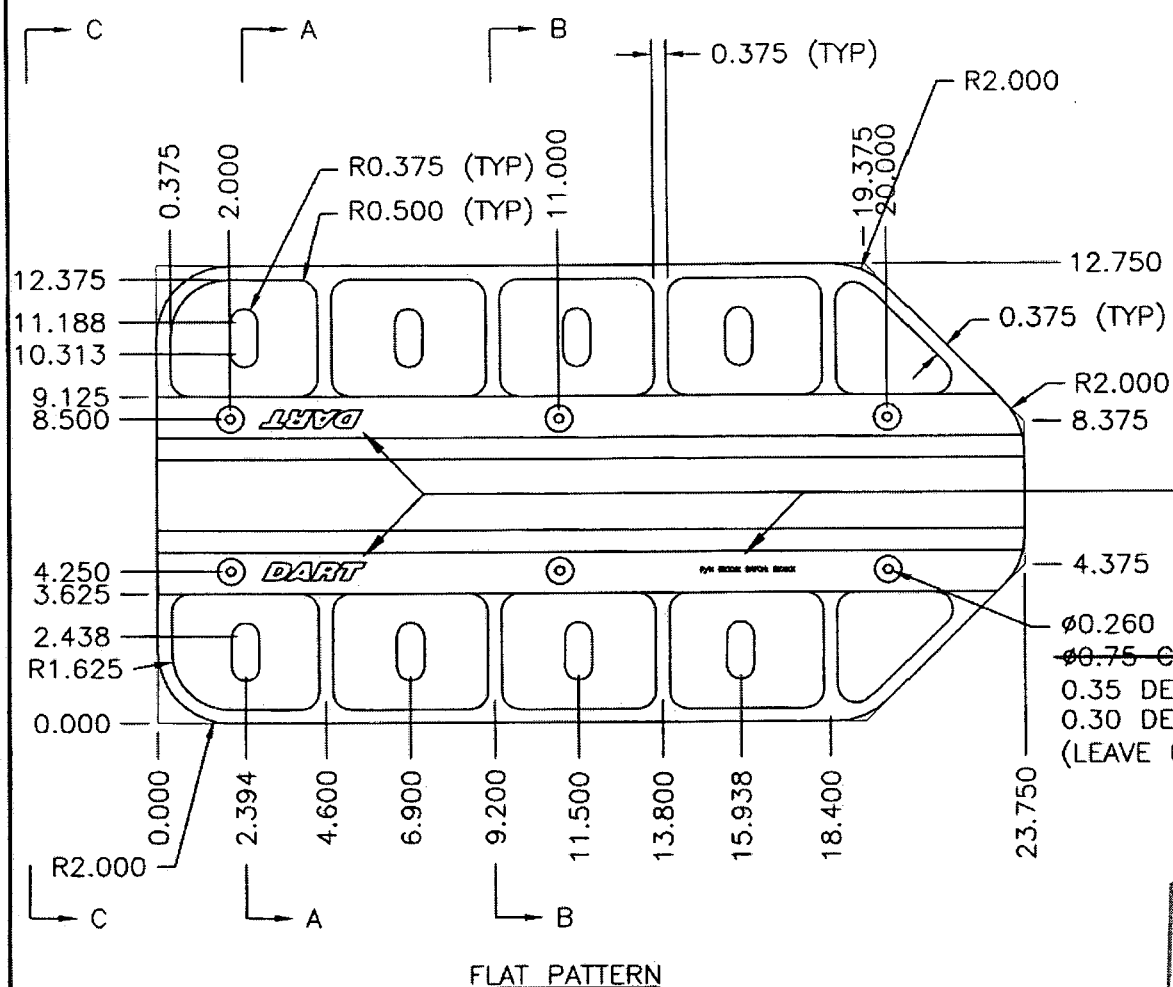
ENGRAVE LOGO TO
MAX DEPTH OF
0.012. ENGRAVE
PART AND BATCH
NUMBERS TO MAX
DEPTH OF 0.010.
(TYPICAL LOCATION
AS ILLUSTRATED)



φ0.260 (TYP)
~~φ0.75 C'BORE~~ ~~φ0.43 C'BORE~~
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)

RELEASED
98.06.17 KS

EFFECTIVE	DEOS
9143	



D2672F: FLAT BEARPAW
D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

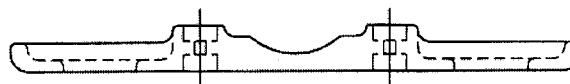
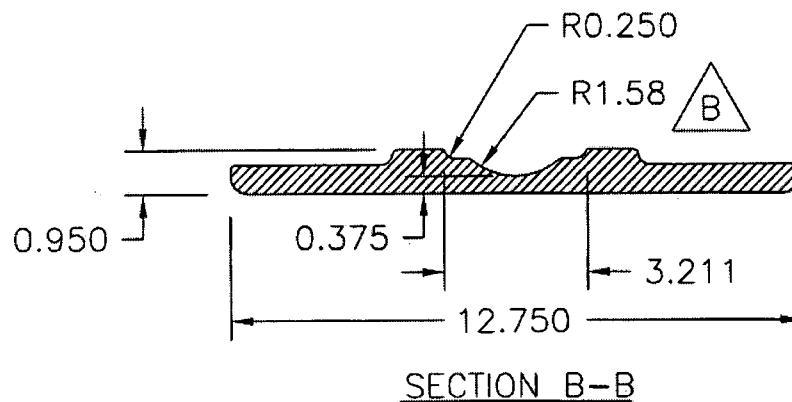
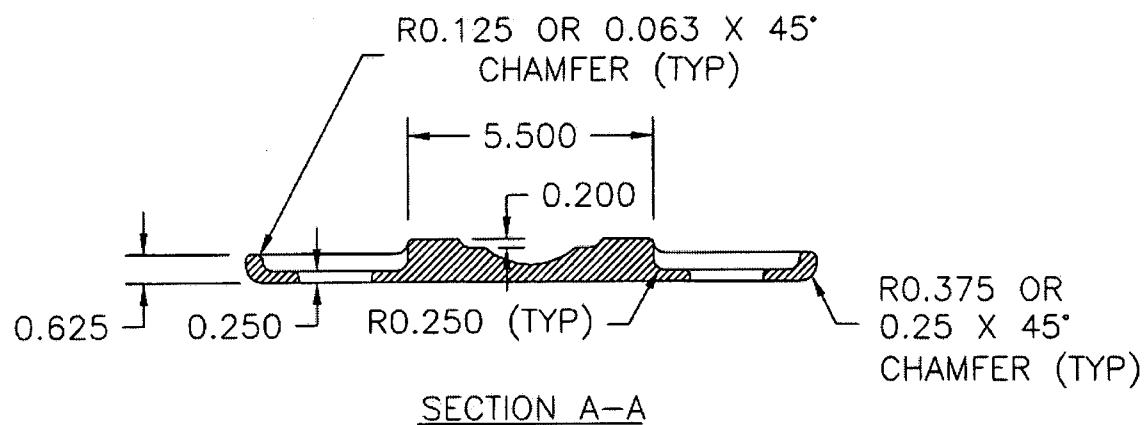
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UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 28731



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>MM</i>	APPROVED <i>KS</i>	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE



SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28731

DART AEROSPACE LTD		Work Order: 28731
Description:		Part Number: 2672
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
L	.063" X 45°	± .010"	.073" X 45°	✓			
K	.625"	± .030"	.624"	✓			
M	.250"	± .010"	.250	✓			
P	.200"	± .030"	.203"	✓			
Q	.250 X 45°	± .030"	.225"	✓			
R	.950"	± .030"	.955"	✓			
S	.375"	± .010"	.374	✓			
N	5.500"	± .030"	5.499"	✓			
	3.211"	± .010"	3.241"	✓			
B	12.750"	± .030"	12.750	✓			
H	Ø .260"	± .006"	.259"	✓			
I	Ø .930"	± .030"	Ø .930"	✓			
J	.300"	± .030"	.315"	✓			
F	.375"	± .030"	.382"	✓			
D	2.000"	± .030"	1.992"	✓			
A	23.750"	± .030"	23.750"	✓			
C	4.250	± .010"	4.251	✓			
E	9.000"	± .010"	9.008	✓			

Measured by: J.F.
Date: 06/10/03

Audited by: SD
Date: 06.10.04

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-559
Job Number	: 36674		
Estimate Number	: 10804		
P.O. Number	: <i>NA</i>	Part Number	: Z_CUSTOM
This Issue	: 09/01/2008 S.O. No. : <i>NA</i>	Drawing Number	: ECN1101
Prsht Rev.	: NC	Project Number	: <i>NA</i>
First Issue	: <i>NA</i> Type : MACHINED PARTS	Drawing Revision	: <i>NA</i>
Previous Run	: 00015	Material	: <i>NA</i>
Written By	: <i>[Signature]</i>	Due Date	: 16/01/2008
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE FROM STOCK:

D206-559-011

B34288 (10x) B30377 (x2) B30800 (x1) B32977 (x5)

D206-559-013

B32728 9x B30340 (2x)

D206-559-021

B28342 (x4)

D206-559-023

B25291 (x3) B34856 (x5)

D206-559-025

B28731 (x4)

ADD NEW PAPERWORK JCAB STC: STC-90-TYO
PER ECN 1101

RETURN TO STK

8/1/10 SD (45x) AS

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20810111

Job Completion



U 28-0-11

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-559
Job Number	: 36674		
Estimate Number	: 10804		
P.O. Number	: <i>N/A</i>	Part Number	: Z_CUSTOM
This Issue	: 09/01/2008 S.O. No. : <i>N/A</i>	Drawing Number	: ECN1101
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: <i>N/A</i>
Previous Run	: 00015	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 16/01/2008 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
REMOVE FROM STOCK:

D206-559-011

B34284 (10x) B30377 (x2) B30800 (x1) B32977 (x5)

D206-559-013

B32728 9x B30340 (2x)

D206-559-021

B28342 (x4)

D206-559-023

✓ B25291 (x3) B34856 (x5)

D206-559-025

B28731 (x4)

ADD NEW PAPERWORK JCAB STC: STC-90-TYO
PER ECN 1101

RETURN TO STK

8/1/10 SD 45x AS

2.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

20810/11

Job Completion



12 28-0-11